

## \* HISTORY \*

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NSN :  
1620001157398

## REQUIREMENTS

## REQUIREMENTS

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FROM WR - ALC

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FURNISHED METHOD CODE LEGEND: X - DATA SUPPLIED (NOT IN EDCARS). G - GOV'T DOCUMENT.

C - CLASSIFIED DOCUMENT.	P - PARTIAL DOCUMENT FURNISHED.	MUST ACQUIRE.
S - FURNISHED WITH SOLICITATION.	V - VENDOR DRAWING;	A - DATA NOT
M - STABLE BASE DRAWING REQUIRED;	(NOT PROVIDED).	AVAILABLE.
FURNISHED WITH CONTRACT AWARD.		

REV:	<b>ENGINEERING DATA REQUIREMENTS</b> (ATTACHMENT "A")	
NOTE: MILITARY SPECIFICATIONS /STANDARDS WILL NOT BE FURNISHED IN THE BID SET.		
1. THE FOLLOWING INSTRUCTIONS ARE FURNISHED FOR THE MANUFACTURE OF <div style="text-align: center;">FITTING, SWIVEL, STEPPED - STRUT ASSY, MLG</div>		
2. PART NUMBER <div style="text-align: center;">4G12586-101A</div>	3. NATIONAL STOCK NUMBER <div style="text-align: center;">1620 00 115 7398</div>	
4. THE FOLLOWING SPECIFICATIONS/STANDARDS, ETC., WILL BE USED IN LIEU OF THE DATA INDICATED. THE SUPERSEDED DATA WILL NOT BE FURNISHED UNLESS SO INDICATED.		
<ol style="list-style-type: none"> <li>a. Machine to meet drawing requirements per LAC 0701, in lieu of DS30003.</li> <li>b. Identify to meet drawing requirements per MIL-STD-130, in lieu of STP 63-001 impression stamping not permitted.</li> <li>c. Penetrant inspect per ASTM E1417, Type I, Method B or C, Level 3 or 4, in lieu of STP 53-201. With the following acceptance/rejection criteria: NO DEFECTS ALLOWED. The intent of NO DEFECTS ALLOWED is that the inspection is conducted at the required sensitivity level and there shall be no indications allowed. The inspector performing the inspection shall be level II certified, with the inspection procedure developed by a level III as specified in NAS-410.</li> <li>d. Use material per SAE AMS-QQ-A-225/8, in lieu of QQ-A-225/8. SAE AMS-QQ-A-200/8 may be used as an alternate material if the preferred material is not available. (Ref. note 19)</li> <li>e. Bearing No. STSKJ100-12A05 in this assembly has been selected and qualified for use, this has been identified under drawing STSKJ100, which is a specification and source control drawing. This drawing lists Vendors by part No. and CAGE code. The contractor must certify that the bearing was procured from the qualified source. The product purchase order will satisfy this requirement.</li> </ol>		
5. Drilling, reaming, and honing to meet drawing specifications, using best shop procedures and the following notes in lieu of STP 51-410.		
<ol style="list-style-type: none"> <li>a. High speed steel (HSS) drills shall be used to drill corrosion resistant steels.</li> <li>b. HSS reamers will be used for rough reaming, and final reaming of steels heat treated below 200 KSI. Carbide or premium grade hi-speed tipped reamers will be used for rough reaming of steels heat treated above 200 KSI.</li> <li>c. Drilling shall never be used as a final machining operation. A minimum of 0.015 inch on diameter shall be left for final reaming. Holes shall be finished by reaming or boring. When jigs, fixtures, or bushings are not used for drilling holes larger than 1/4 inch, the holes will be piloted with a center drill. Chemical, electrical, or electrochemical hole producing methods shall not be used as a final surface producing method without prior approval from OO-ALC/LGHLEN.</li> <li>d. Honing stones shall be of 150 to 500 alumium oxide grit with a medium-hard bond and preferably a multi-head stone. Heads with steel shoes or wipers shall not be used.</li> <li>e. Rough reaming, the reamer length shall be as short as consistent with required penetration. Final reaming, the diameter cut shall produce a hole that meets the requirements of the engineering drawing.</li> </ol>		
PREPARED BY <div style="text-align: center;">Daryl R. Clark</div>	SYMBOL <div style="text-align: center;">LGMPM</div>	DATE <div style="text-align: center;">26 Mar 03</div>

REV:	ENGINEERING DATA REQUIREMENTS CONTINUATION SHEET (ATTACHMENT "A")	
PART NUMBER	NATIONAL STOCK NUMBER	
4G12586-10A	1620 00 115 7398	
<p>e. Rough reaming, the reamer length shall be as short as consistent with required penetration. Final reaming, the diameter cut shall produce a hole that meets the requirements of the engineering drawing.</p> <p>f. Honing shall be used as a final operation where a surface finish better than 125 roughness height ratio is required, and cannot be produced by other means.</p> <p>g. Carbide drills can be operated at higher speeds than HSS drills, but must be used with caution. They must not be used in dull or chipped condition.</p> <p>6. Finish per the following in lieu of DS 30000, and finish codes AAA, 17, 54, and 74-74.</p> <p>a. Hard anodize per MIL-A-8625, Type III, Class 2, (color per FED-STD-595, color No. Approximate to 37038 black). (code AAA)</p> <p>b. Primer wash not required. (code 17)</p> <p>c. One coat of epoxy primer per MIL-PRF-85582, Type I, Class 2. (code 54). Alternate, One coat of epoxy primer per MIL-PRF-23377, Type I.</p> <p>d. Two coats of top coat per MIL-PRF-85285, Type I. (color white, No. 17925 per FED-STD-595). (code 74-74)</p> <p>7. Material Review Board disposition:</p> <p>a. OO-ALC/LLGHLEN system engineering retains all rights to review and accept MRB dispositions prior to shipment of discrepant item. All deviations, minor and major, from the engineering drawing package will be submitted for MRB disposition.</p>		
PREPARED BY	SYMBOL	DATE
Daryl R. Clark	LGMPM	26 Mar 03

CONTRACT DATA REQUIREMENTS LIST  
(1 Data Item)

# INSTRUCTIONS FOR COMPLETING DD FORM 1423

(See DoD 5010.12M for detailed instructions.)

## FOR GOVERNMENT PERSONNEL

- Item A. Self-explanatory.
- Item B. Self-explanatory.
- Item C. Mark (X) appropriate category: TDP - Technical Data Package; TM - Technical Manual; Other - other category of data, such as 'Provisioning', 'Configuration Management', etc.
- Item D. Enter name of system/item being acquired that data will
- Item E. Self-explanatory (to be filled in after contract award).
- Item F. Self-explanatory (to be filled in after contract award).
- Item G. Signature of preparer.
- Item H. Date CDRL was prepared.
- Item I. Signature of CDRL approval authority.
- Item J. Date CDRL was approved.
- Item 1. See DoD FAR Supplement Subpart 4.71 for proper numbering.
- Item 2. Enter title as it appears on data acquisition document cited in Item 4.
- Item 3. Enter subtitle of data item for further definition of data item (optional entry).
- Item 4. Enter Data Item Description (DID) number, military specification number, or military standard number listed in DoD 5010.12-L (AMSDL), or one-time DID number, that defines data content and format requirements.
- Item 5. Enter reference to tasking in contract that generates requirement for the data item (e.g. Statement of Work paragraph number).
- Item 6. Enter technical office responsible for ensuring adequacy of the data item.
- Item 7. Specify requirement for inspection/acceptance of the data item by the Government.
- Item 8. Specify requirement for approval of a draft before preparation of the final data item.
- Item 9. For technical data, specify requirement for contractor to mark the appropriate distribution statement on the data (ref DoDD 5230.24).
- Item 10. Specify number of times data items are to be delivered.
- Item 11. Specify as-of date of data item, when applicable.
- Item 12. Specify when first submittal is required.
- Item 13. Specify when subsequent submittals are required, when applicable.
- Item 14. Enter addresses and number of draft/final copies to be delivered to each addressee. Explain reproducible copies in Item 16.
- Item 15. Enter total number of draft/final copies to be delivered.
- Item 16. Use for additional/clarifying information for items 1 through 15. Examples are: Tailoring of documents cited in Item 4; Clarification of submittal dates in Items 12 and 13; Explanation of reproducible copies in Item 14; Desired medium for delivery of the data item.

## FOR THE CONTRACTOR

Item 17. Specify appropriate price group from one of the following groups of effort in developing estimated prices for each data item listed on the DD Form 1423.

a. Group I. Definition - Data which is not otherwise essential to the contractor's performance of the primary contracted effort (production, development, testing and administration) but which is required by DD Form 1423.

Estimated Price - Costs to be included under Group I are those applicable to preparing and assembling the data item in conformance with Government requirements, and the administration and other expenses related to reproducing and delivering such data items to the Government.

b. Group II. Definition - Data which is essential to the performance of the primary contracted effort but the contractor is required to perform additional work to conform to Government requirements with regard to depth of content, format, frequency of submittal, preparation, control, or quality of the data item.

Estimated Price - Costs to be included under Group II are those incurred over and above the cost of the essential data item without conforming to Government requirements, and the administrative and other expenses related to reproducing and delivering such data item to the Government.

c. Group III. Definition - Data which the contractor must develop for his internal use in performance of the primary contracted effort and does not require any substantial change to conform to Government requirements with regard to depth of content, format, frequency of submittal, preparation, control, and quality of the data item.

Estimated Price - Costs to be included under Group III are the administrative and other expenses related to reproducing and delivering such data item to the Government.

d. Group IV. Definition - Data which is developed by the contractor as part of his normal operating procedures and his effort in supplying these data to the Government is minimal.

Estimated Price - Group IV items should normally be shown on the DD Form 1423 at no cost.

Item 18. For each data item, enter an amount equal to that portion of the total price which is estimated to be attributable to the production or development for the Government of that item of data. These estimated data prices shall be developed only from those costs which will be incurred as a direct result of the requirement to supply data, over and above those costs which would otherwise be incurred in performance of the contract if no data were required. The estimated data prices shall not include any amount for rights in data. The Government's right to use data shall be governed by the pertinent provisions of the contract.